

Work Order ID 92993***92993***

Page 1

Tuesday, November 13, 2012 11:15:13 AM

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/14/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: 

Date: 12-11-13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9590

C

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D350-567-141 CHG002

0.00

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

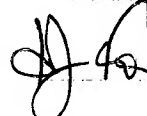
120

QC

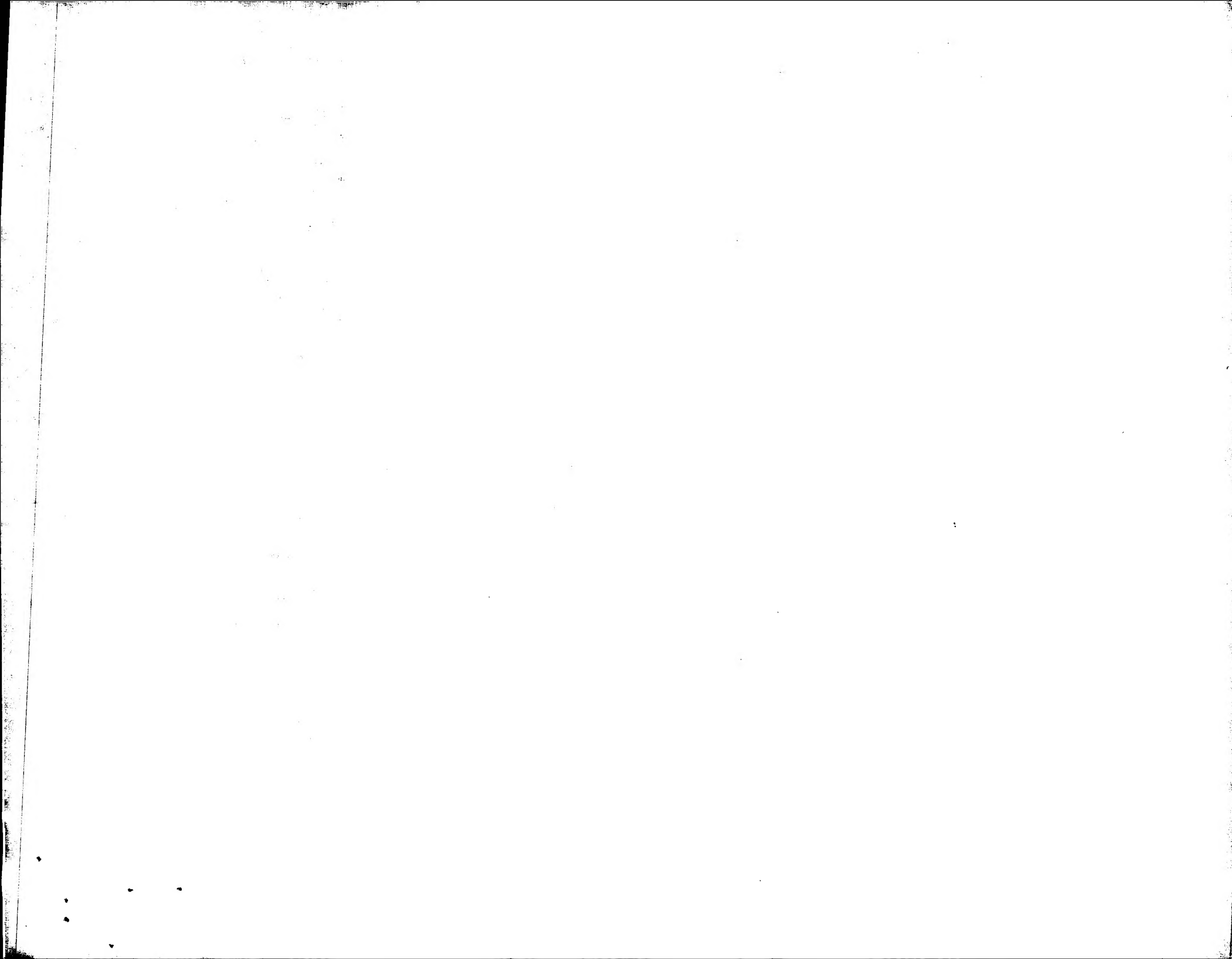
Quality Control

Memo

0.00

 46 MGS 12-11-13
(2)2 12/11/13 JB


12114



Work Order ID 92993***92993***

Page 2

Tuesday, November 13, 2012 11:15:13 AM

Item ID: D350-567-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/14/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-567-141

Location: 59A B

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

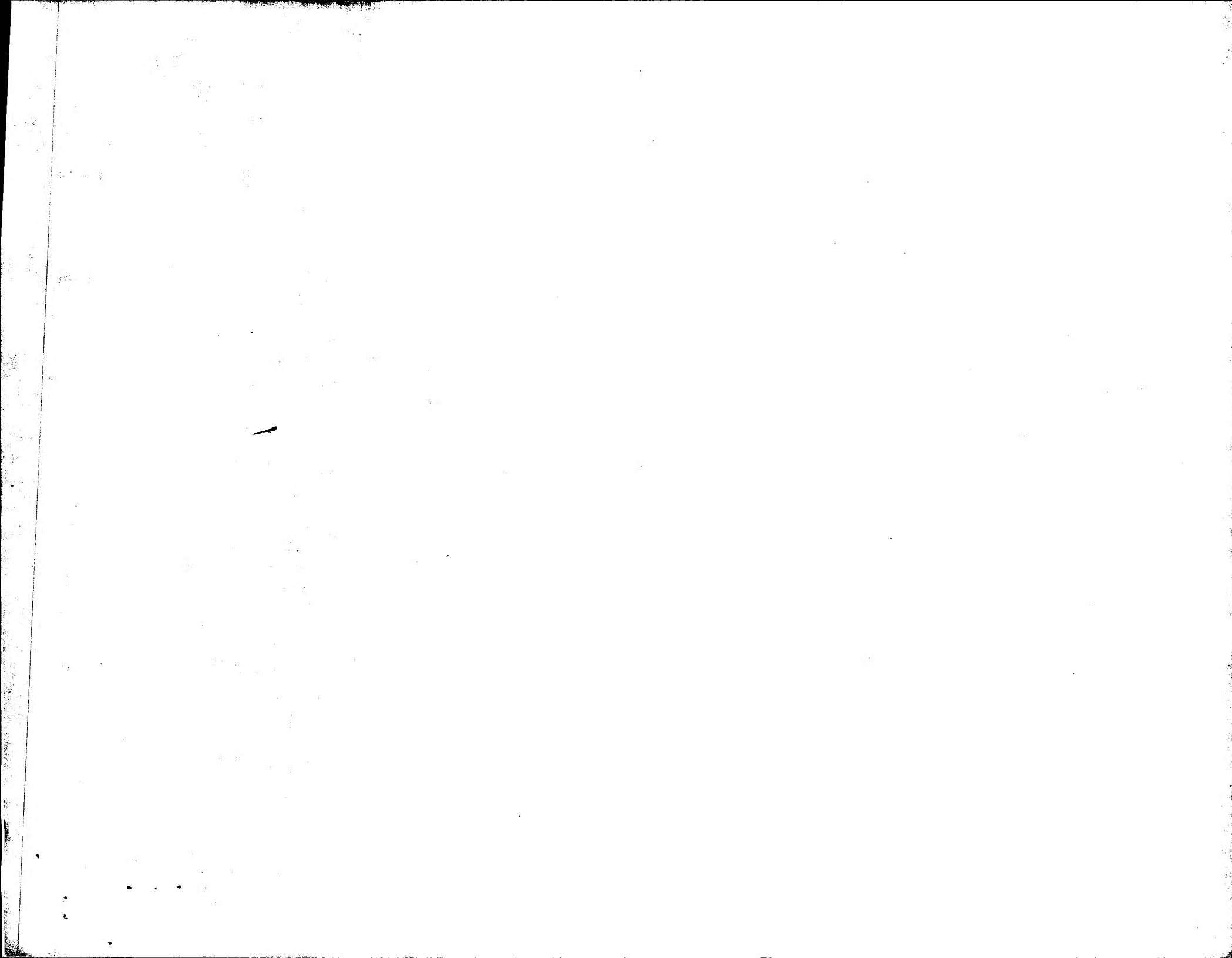
Memo

0.00

Quality Control

12/11/15

mt
12-11-14



Picklist Print

Tuesday, November 13, 2012 11:15:13 AM

Page 1

Work Order ID: 92993

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012

Required Date: 11/14/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1 Window Seal (D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT. 24" x 4 SMS	SMS	Manufactured	No			110	f	411.1400	2	4	✓	12/11/13	SL
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST408		411.14							
				56881		0.75							
				81021		2							
				81868		408.39			81868				
D434-041 Fwd Bracket Assembly SMS		Manufactured	No			110	Each	7.0000	1	2	✓	12/11/13	SL
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		6							
				85859		6			85859				
				ST274		1							
				83538		1							
D4434-047 Cover Assembly SMS		Manufactured	No			110	Each	4.0000	1	2	✓	12/11/13	SL
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST273		4							
				85839		4			85839				
D4435-045 T/R Bellcrank Cover Assembly SMS		Manufactured	No			110	Each	3.0000	1	2	✓	12/11/13	SL
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST273		3							
				83535		3			83535				
D4435-9 Bracket SMS		Manufactured	No			110	Each	4.0000	2	4	✓	12/11/13	SL
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST441		4							
				87534		4			87534				

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

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Page 2

Work Order ID: 92993

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012

Required Date: 11/14/2012

Start Qty: 2.00

Required Qty: 2.00

D4436-041

Aft Bracket Assembly

Manufactured No

110 Each 2.0000

1 2 ✓ JB

Sms 2X

Location

Loc Qty

Loc Code

ST273

2

85861

2

85861

D4441-1

Rubber Seal

Manufactured No

110 f 655.1146

2 4 ✓ JB

(D4441-1-240) CUT (1) AT 24.00" PER KIT

Location

Loc Qty

Loc Code

ST412

655.1146

74760

6.119

79385

0.0476

80763

163.54

86185

485.408

80763

AN3-3A

Bolt

Purchased No

110 Each 300.0000

7 14 ✓ JB

Sms 27

Location

Loc Qty

Loc Code

ST350

300

122800

200

123352

100

122800

AN525-832R7

Screw

Purchased No

110 Each 438.0000

2 4 ✓ JB

Sms 27

Location

Loc Qty

Loc Code

ST345

438

120519

34

120560

404

120560

MS21042L06

Nut

Purchased No

110 Each 345.0000

7 14 ✓ JB 12/11/13

Sms 27

Location

Loc Qty

Loc Code

315

272

122441

272

ST317

73

122151

73

122441

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Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 92993

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012

Required Date: 11/14/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042108

Nut

Purchased

No

110

Each

882.0000

2

4

Location

Loc Qty

Loc Code

315

9

122452

9

ST315

500

122814

500

ST317

373

122141

373

110

Each

2,402.0000

5

10

Location

Loc Qty

Loc Code

316

619

122452

619

ST300

225

117885

32

119017

55

119075

138

ST314

1237

123265

1237

ST317

321

122141

321

122141

123265

12/11/13

MS21042113

Nut

Purchased

No

SNP 27

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Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Picklist Print

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Page 4

Work Order ID: 92993

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/13/2012

Required Date: 11/14/2012

Start Qty: 2.00

Required Qty: 2.00

MS2105913

Nut Plate

Purchased

No

110

Each

227.0000

2

4

V

20

Location

Loc Qty

Loc Code

302

10

121185

10

314

3

122452

3

ST301

28

118614

8

119546

20

ST302

124

120308

13

120833

1

121444

100

121524

10

ST316

62

122814

62

MS35206-229

Screw

Purchased

No

110

Each

79.0000

7

14

V

20

Location

Loc Qty

Loc Code

ST293

79

121039

79

121039

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NCR: Yes / No

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Picklist Print

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Page 5

Work Order ID: 92993

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

NASH149F0332P

WASHER

Purchased

No

110

Each

1,182.0000

Start Date: 11/13/2012

Required Date: 11/14/2012

Start Qty: 2.00

Required Qty: 2.00

12 24

JB

JB

Location

Loc Qty

Loc Code

275

206

122441

206

122441

ST275

776

117735

13

119225

8

121259

138

121825

14

122063

600

17317

3

ST295

200

123352

200

Purchased

No

110

Each

669.0000

14 28

JB

JB

Location

Loc Qty

Loc Code

ST275

669

117317

15

120560

654

120560

Purchased

No

Each

729.0000

4

JB

12/11/13

Location

Loc Qty

Loc Code

ST275

729

117316

215

121039

514

121039

JB

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REFERENCE ONLY

SMA

2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
9	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELL CRANK COVER ASSEMBLY
1	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
1	AN3-3A	BOLT
1	AN525-832R7	SCREW
1	MS21042L06	NUT (OR MS21042-06)
1	MS21042L08	NUT (OR MS21042-08)
1	MS21042L3	NUT (OR MS21042-3)
1	MS21059L3	NUTPLATE
1	MS35206-229	SCREW
1	NAS1149F0332P	WASHER (AN960-10L)
1	NAS1149FN616P	WASHER (OR AN960-6L)
1	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 12.03.13
CERT. NO.: SH92-18
ISSUE NO.: 6

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MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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